

P-TARKET-018/WO

## CLAIMS

1. A rolling method for making a multilayer product comprising on a polymeric backing, at least one wear layer in a thermoplastic polymer, characterized in that it comprises the following steps:

5       • preheating the backing, preferably at a temperature between 100 and 130°C,

• cold application of the wear layer on the preheated backing.

10      • melting the wear layer in order to ensure that it adheres with the backing, preferably at a temperature between 120°C and 180°C,

• cooling the obtained product in order to bring it to a temperature close to room temperature.

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2. The method according to claim 1, characterized in that the wear layer comprises one or more intermediate layers.

3. The method according to claim 1 or 2, characterized in that the polymeric backing and the wear layer comprise olefinic polymers.

20      4. The method according to any of claims 1 to 3, characterized in that the intermediate layer contains more than 5 parts by weight of metallocene for 100 parts by weight of olefinic polymer.

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5. The method according to any of claims 1 to 54, characterized in that an additional polyolefinic layer of low density ethylene is interposed between the backing and the intermediate layer.

6. The method according to claim 65, characterized in that the additional layer comprises low density polyethylene and optionally, one or more additives selected from the group of fatty acids and silica.

5 7. The method according to any of claims 1 to 76, characterized in that a polyurethane surface layer is applied on the wear layer.

10 8. The method according to any of claims 1 to 7, characterized in that melting of the wear layer to ensure that it adheres to the backing is performed in a heating oven comprising one or more gas blowing nozzles, pressure being exerted on the backing-wear layer assembly by means of the gas blowing nozzle.

15 8-9. A doubling equipment comprising:

- a backing feeder device,
- a backing preheating station,
- a wear layer feeding device,
- a device for putting the backing and the wear layer into contact,
- a heating oven comprising one or more gas blowing nozzles,
- a conveyor device conveying the backing and the wear layer through said heating oven,

25 30 the backing being conveyed via the feeder device into the preheating station in which it is preheated to a temperature between 100 and 130°C, and then the preheated backing being put into contact with the wear layer in the contacting device, the backing having been conveyed by the backing feeding device, the backing and the wear layer being then

conveyed through the heating oven, inside which the wear-layer-and-backing assembly is heated to a temperature between 120 and 180°C and conveyed through the oven on the conveyor device, pressure being exerted during this conveyance on the backing-wear layer assembly by means of the gas blowing nozzle in order to melt together the wear layer and the backing.

10. A rolling method for manufacturing a multilayer product applying a doubling equipment according to claim 9.

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9-11. The use of products obtained according to any of claims 1 to 8<sup>10</sup>, for making floor or wall claddings.